

100	Hardinge CNC LATHE SMALL	0.00			
<b>*100*</b>					
Hardinge	<b>Memo</b>	0.00			
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA711 & DWG D3670 FOLIO REV: <u>AA</u>				
	DWG REV: <u>A</u>				
	2-DEBURR AS REQUIRED				
110	QC2- Inspect parts off machine FAI/FAIB	0.00			
<b>*110*</b>					
QC	<b>Memo</b>	0.00			
Quality Control					
120	QC8- Inspect parts - second check	0.00			
<b>*120*</b>					
QC	<b>Memo</b>	0.00			
Quality Control					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77500

\*77500\*

Page 2

December-09-11 8:50:22 AM

Item ID: D3670-4-200

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: SPACER

Start Date: 09/12/2011 Start Qty: 80.00

\*80\*

Cust Item ID:

Required Date: 16/12/2011 Req'd Qty: 80.00

\*80\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00				80	2	BE 12-01-06	
*130*									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00				<del>80</del>	<del>2</del>	<del>BE 12-01-06</del>	
*140*									
QC	Memo	0.00							
Quality Control									

12/1/10 *[Signature]*  
MF 12-01-09

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**NOTE:** Date & initial all entries

# Picklist Print

December-09-11 8:50:26 AM

Page 1

Work Order ID: 77500

\*77500\*

Parent Item: D3670-4-200

\*D3670-4-200\*

Parent Item Name: SPACER

Start Date: 09/12/2011

Required Date: 16/12/2011

Start Qty: 80.00

Required Qty: 80.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No				f	261.1230		28.81441			

\*M6061T6T0 3125W 058\*

ALUM TUBE .3125 x .058w

\*\*

31.417'

SL 11/12/13

### Location

### Loc Qty

### Loc Code

MAT013

261.123

116793

1.667

116939

23.972

117400

16.9

118438

14.584

119678

204

31.417'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

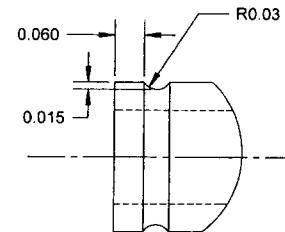
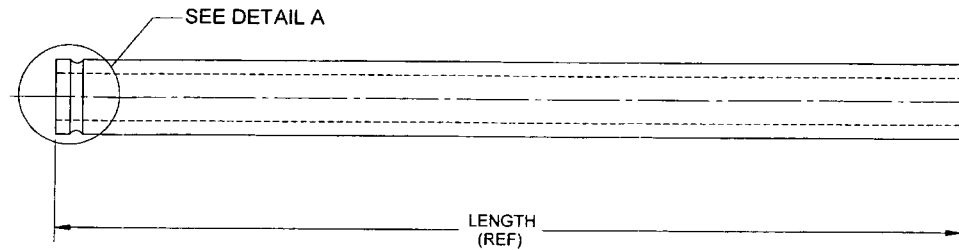
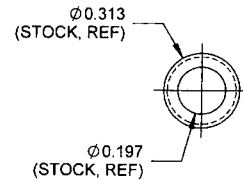
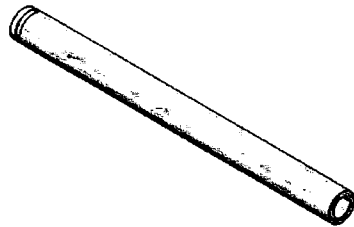
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# SPECIFICATION CONTROL DRAWING



DETAIL A  
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER  
LENGTH

WHERE XXXX IS LENGTH IN INCHES  
EG: 3.750" LONG SPACER: D3670-3750

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77500-MC-J

1112409

RELEASED  
07.11.06

## NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

A		NEW ISSUE		DC	07.10.19
REV.		DESCRIPTION		BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	BC				
CHECKED	h	DRAWING NO.	REV. A		
MFG. APPR.	BO	D3670	SHEET 1 OF 1		
APPROVED	BO	TITLE	SCALE		
DE APPR.	h	SPACER	2:1		
DATE	07.10.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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